

Date: Tuesday, 08/04/2008 4:55:02 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLADE FITTING
Job Number	: 38466		
Estimate Number	: 12300		
P.O. Number	:	Part Number	: D3488042
This Issue	: 08/04/2008 S.O. No. :	Drawing Number	: D3488 / DSK101
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B / D
Previous Run	: 38100	Material	:
Written By	:	Due Date	: 06/05/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JD 08-4.09</u>		
Comment	: Est Rev:A New Issue 06-02-28 JLM Est Rev:B As per Rev B 06-03-30 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6103003	alum billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Alluminum Round Billet D6103-003

Batch: 38101 x 2

36236 x 8

26 08/04/15

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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(P10) ->

Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Dwg DSK 101 & Folio FA627

2-Deburr

26 08/04/15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

26 08/04/15

(10)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA627 & Dwg D3488

2-Deburr

J.L 08/05/13

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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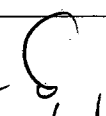
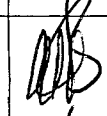


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/05/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3488-042 PAR #: N/A Fault Category: Prod/Machined Part NCR: Yes No DQA: D Date: 08/05/22
 QA: N/C Closed: D Date: 08/05/22

NCR: <u>38466</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/23	2-D	0.297" hole was drilled to large by 0025" (0.321). RC hole wasn't drilled deep enough so when it was re-drilled it was too large. Also the plug was not installed during drilling.	 08/04/24	Scrap and Destroy no replace. 08.04.23 Qty (+1)	SP 08/05/22 for Mathin Larche	 08/05/22	 08/04/24	 08/04/23
								 08/04/23

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:55:02 PM
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 38466

Part Number: D3488042

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

(10)

28 08/04/15

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. L.

(10X)

30 min

15/05/2008

S.244 11.05

#1 321

#2 338466

#3 D3488042

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107925

M. L.

08/0

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-15 X10

10.0 ALS71032225 INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert M100489

X

11.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

sl

08-05-15

(V10)

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/15 (44)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-22

sl

08-05-15

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:55:02 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 38466

Part Number: D3488042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/22 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

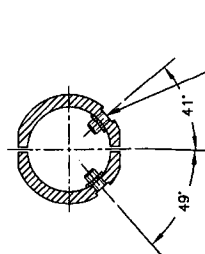
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

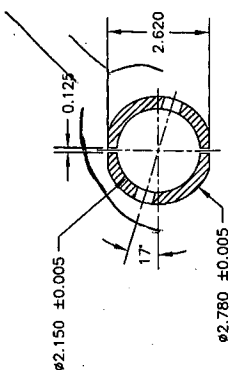
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

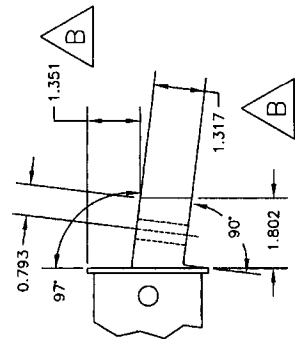
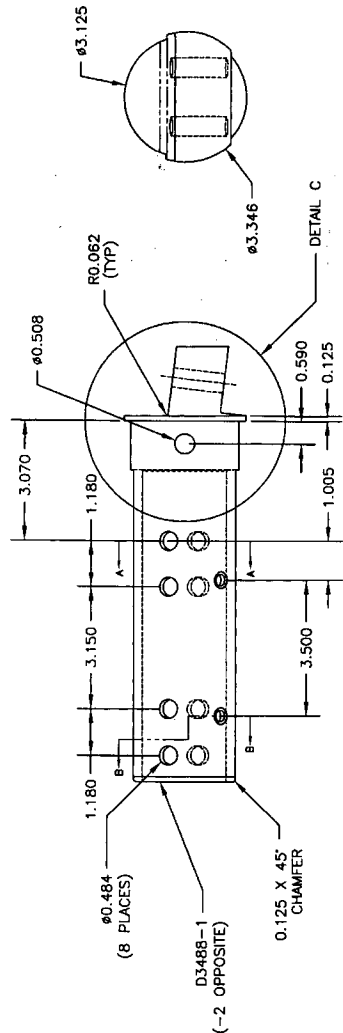
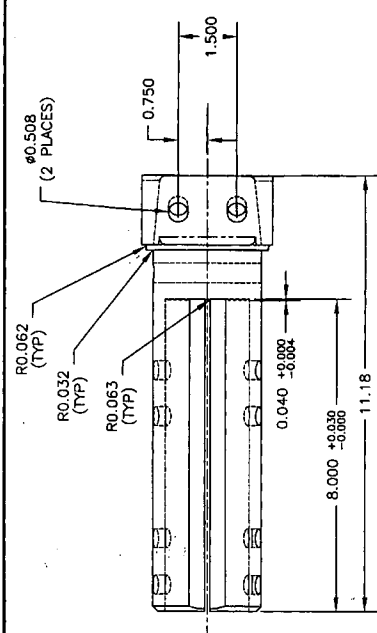
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WORK ORDER
NO. 38468



SECTION B-B
C BORE $\phi 0.430 \times 0.100$
INSTALL ALSA-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



SECTION A-A



RELEASED
R 06.03.87 PH
REV. D'S
EIN #737

D3488-041 SHOWN (D3488-042 OPPOSITE)

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
4	D3488-041	BLADE FITTING ASSEMBLY (LH)
4	D3488-042	BLADE FITTING ASSEMBLY (RH)
1	D3488-1	BLADE FITTING (LH)
1	D3488-2	BLADE FITTING (RH)
4	ALSA-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING
1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR
PER QQ-A-225/9

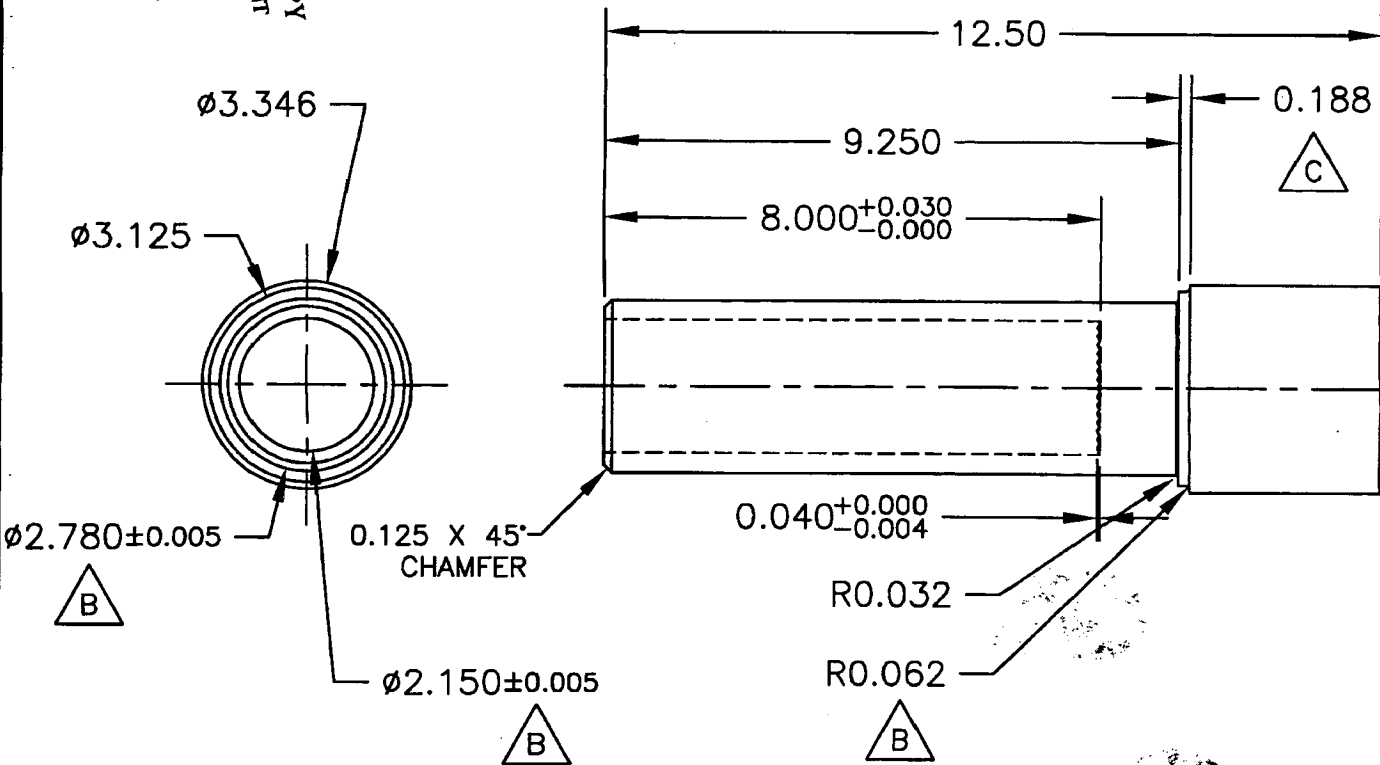
- 2) FINISH: (REF. DART MATERIAL SPEC M7075T73R)
ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
4) INSTALL INSERTS AFTER POWDER COAT
5) ALL DIMENSIONS ARE IN INCHES
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DATE	CHECKED	APPROVED	DRAWN BY	NEW ISSUE	CHANGE THICKNESS
A	06.03.15	PH	PH	PH	05.12.20	B
DART DART AEROSPACE USA, INC. PORT HADSPER, VA						REV. B SHEET 1 OF 1 SCALE 1:3

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ART

DESIGN	DRAWN BY		DART AEROSPACE USA, INC.	
PH	PH		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. D	
PH	PH	DSK 101	SHEET 1 OF 1	
DATE	TITLE		SCALE	
06.05.09	D3488-1/-2 TURNING DETAIL		1:3	
A	05.12.21	NEW ISSUE		
B	06.03.02	ADD TOLERANCES AND RADIUS		
C	06.04.17	0.188 WAS 0.125		
D	06.05.09	REMOVE DIAMETER FOR CHAMFER		



DSK 101

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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